

Date: Monday, 9/18/2006 2:30:36 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PEDAL MOUNT ANGLE  
 Job Number : 28643  
 Estimate Number : 10780  
 P.O. Number : N/A Part Number : D32083  
 This Issue : 9/18/2006 S.O. No. : N/A Drawing Number : D3208 REV A 1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A 1  
 Previous Run : 21790 Material :  
 Due Date : 9/30/2006 Qty: 4 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est: B04.05.25 Material changed for Step 4KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S063 6061-T6 .063 Sheet



Comment: Qty.: 0.0692 sf(s)/Unit Total : 0.2768 sf(s)  
 6061-T6 .063 Sheet  
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick  
 (M6061T6S.063)  
 Batch: M100285

FF 06.09.21 4

2.0 SHEAR SHEAR



Comment: SHEAR  
 Cut blank: 1.651" x 5.250" grain along 1.651"  
 Identify for D3208-3

FF 06.09.21 4

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Drill and Fillet D3208-3 corner as per Dwg D3208  
 Identify as D3208-3

FF 06.09.21 4

4.0 BRAKE NC NC BRAKE



Comment: NC BRAKE  
 Deburr D3208-3  
 Form D3208-3 as per Dwg D3208  
 Polish any marks on part within 01. of Dwg D3208

FF 06.09.21 4

SB 06/10/04 4

FF 06-10-05 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/10/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.10.05 PF	4	Hole for finishing (0.098) on wrong side.	CP 06.10.05 P QSI 042	Dwg not clear as to bend direction. Bending either way acceptable & Part is OK	PP 06-10-05	CP 06.10.05 P QSI 042		

NOTE: Date & initial all entries

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Drawing Name: PEDAL MOUNT ANGLE

Job Number: 28643

Part Number: D32083

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*J 06-10-05 (4)*

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*a.m. 06-10-06*

*(4)*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

*P 06/10/06 (4)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*57415*

*P 06/10/06 (4)*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*P 06/10/10 (4)*

Job Completion



*4 06/10/06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

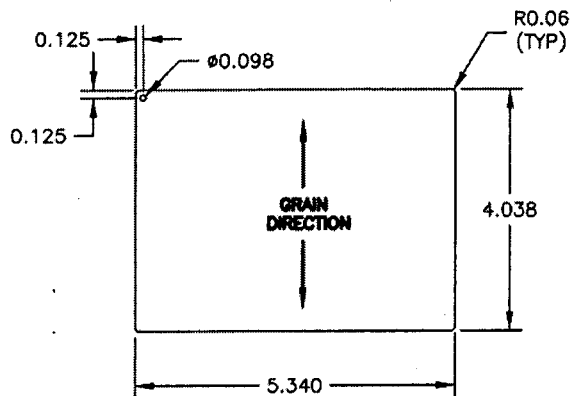
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

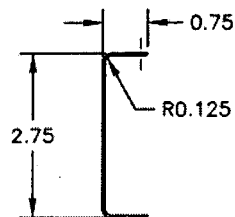


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CHECKED #	APPROVED #	DRAWING NO. D3208	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:3
A	04.01.27	NEW ISSUE	
AI	# RF 04.05.25	CHANGE DIM; NOTE 3) CHANGE	

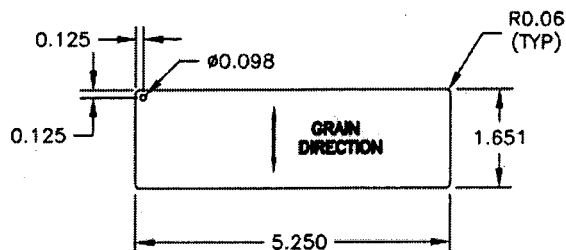
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04.04.05 #



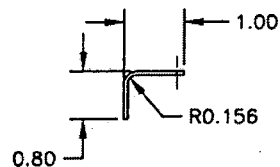
2 D3208-1 DOUBLER  
FLAT PATTERN



D3208-1 DOUBLER  
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE  
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE  
BEND DETAIL

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 3) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063" THICK (M6061T6S.063)



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WORK ORDER  
NO. 28643

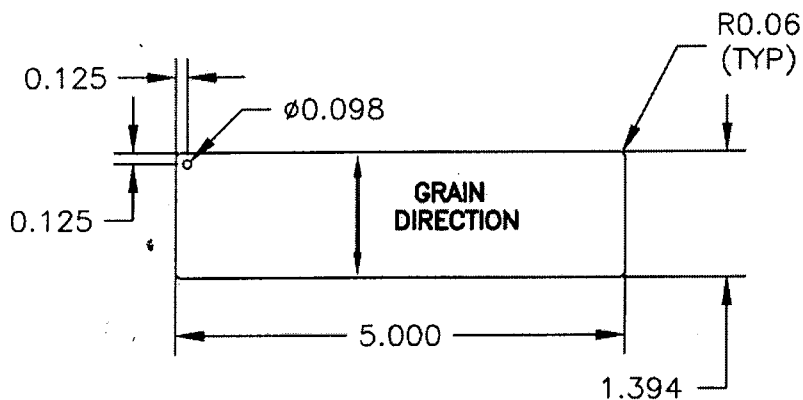
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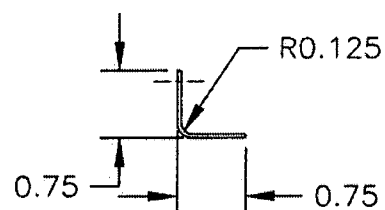
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DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

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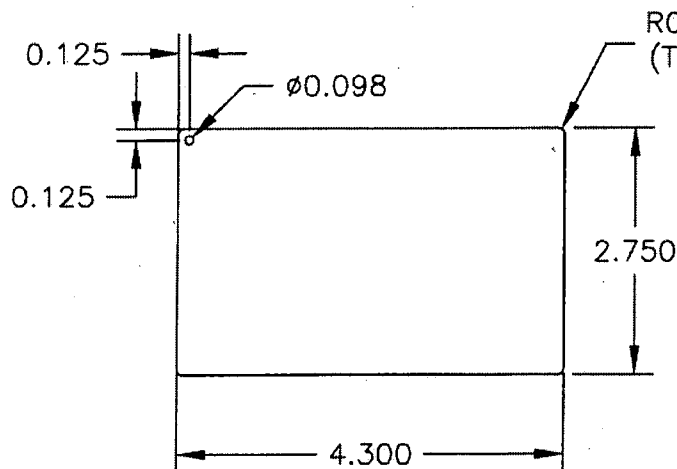


2

**D3208-5 MOUNT ANGLE  
FLAT PATTERN**

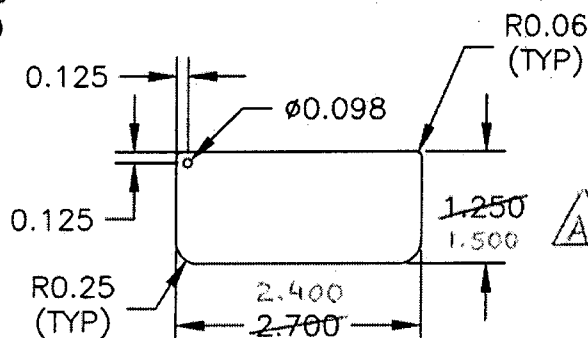


**D3208-5 MOUNT ANGLE  
BEND DETAIL**



2

**D3208-7 FILLER**



2

**D3208-11 FILLER**

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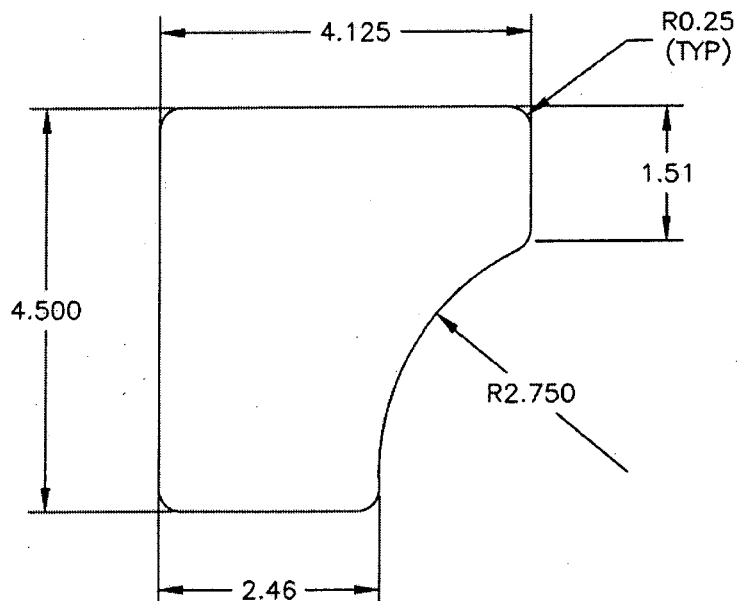
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DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

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04.04.05 [Signature]



D3208-9 DOUBLER

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